

Work Order ID 52991

October 20, 2009 12:57:50 PM



ASAP
ASAP

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Item ID: D3954-9 Accept

Revision ID: *AB*

Item Name: GWT Chain Pin

Start Date: 10/21/2009 Start Qty: 10.00

Required Date: 10/23/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *MF* Date: *09-10-20* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
<i>A3954</i>	<i>B</i>	<i>10/10/29</i>							

100 0.00 *30* *0*

Hardinge Memo 0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA & DWG

FOLIO REV: *N/A*

DWG REV: *AB*

2-DEBURR AS REQUIRED

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00 *30* *0*

Quality Control

SA 09/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3954-9

Accept



Setup Start



Revision ID: A

Stop



Item Name: GWT Chain Pin

Start Date: 10/21/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mf 09/10/26			30	0		
130 Packaging Packaging	Identify as per dwg & Stock Location: 139 Memo	0.00 0.00							P. 9/14/26 (30)
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/10/29 mf 09-10-27

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Picklist Print

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Work Order ID: 52991

Parent Item: D3954-9RevA

Parent Item Name: GWT Chain Pin



Comments:

Start Date: 10/21/2009

Required Date: 10/23/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	45.4645	1.5789			
												

304 ROUND BAR 0.375

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

45.46447895

110166

3.32

110472

6.41

112058

0.31317895

112473

35.4213

1018 RB 375

M110860 ??

1.5789

SN 0910/24

W/O:		WORK ORDER CHANGES					
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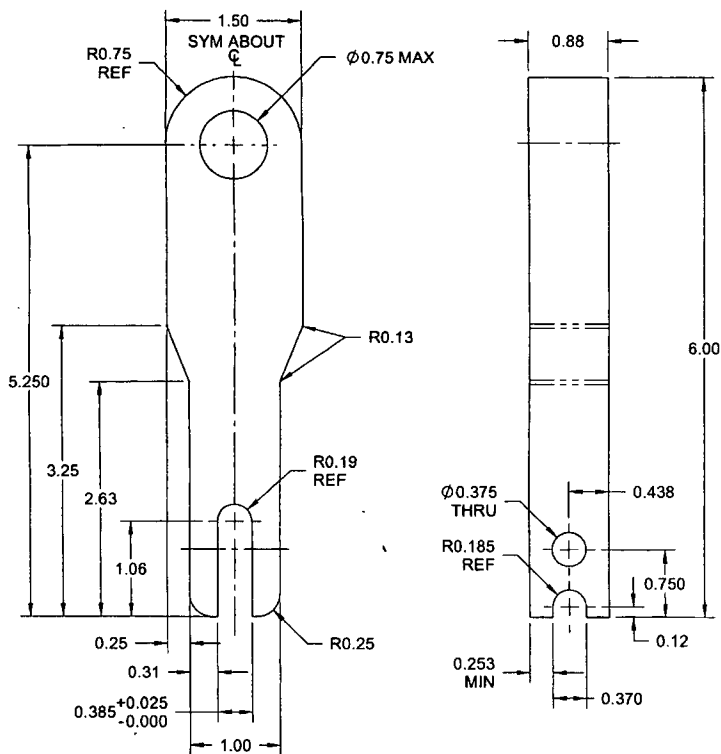
W/O:		WORK ORDER CHANGES					
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D3954-5 CHAIN LUG

NOTES:

1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

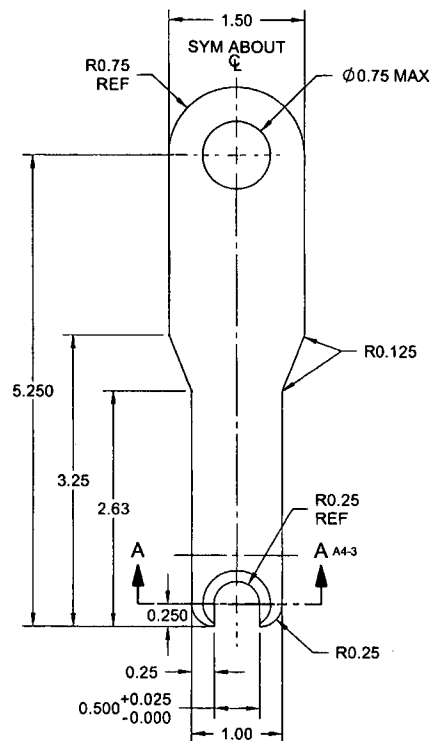
9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

ALTERNATE MATERIAL:

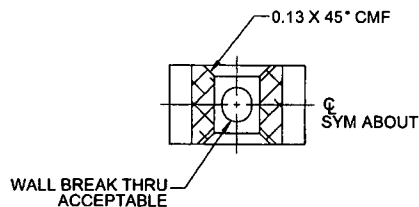
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2 **B**
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

SECTION A-A C3-3

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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RELEASED
2009-10-19

52991

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